

Date: Monday, 2/20/2006 8:03:19 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING		
Job Number	: 25881		Part Number	: D32161		
Estimate Number	: 10869		Drawing Number	: D3216 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 2/20/2006	S.O. No. : N/A	Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 2/27/2006		
Previous Run	: 25480		Qty:	50	Um:	Each
Written By	: <u>SEE COMMENT BELOW</u>					
Checked & Approved By	: <u>SPR ABOVE DATE & USEC</u>					
Comment	: Est: A 03.10.28 New Issue KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
<p>Comment: PURCHASING Issue P/O: <u>6014</u> U 06-02-20 SD Email or Ship DXF file to vendor Laser Cut D3216-1 Fitting as per Dwg D3216 Material release note is required</p>		
2.0	D32161F	Fitting 
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Fitting</p>		
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
<p>Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <u>Po 8/2/24</u> 6</p>		
4.0	QC6	DIMENSIONAL CHECK 
<p>Comment: DIMENSIONAL CHECK <u>Ja-02-24</u></p>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. Tumble until parts have a polished finish. <u>SD 04/02/28</u> 30</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Jan-28

Comment: INSPECT WORK TO CURRENT STEP

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 414

Feb 28 (30)

8.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

6/03/01

Job Completion



1/06-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

WLCR 302655 P51020PC002

OCT-20-2005 15:06 OLBERT METAL SALES
OLBERT METAL SALES LTD
WILKINSON STEEL AND METALS P/N PS1020PC002V
 STAINLESS CR COIL 304
 11GA (11.110) X 48.0000"
 PART NO.

ILC PO 110913
 Dart PO 614

985 795 1320 P.02/2
 BL/VA-000504-001 200505
 Pg 1/1

Certified in accordance to Pressure Equipment Directive 97/23/E.C. Annex L
 Paragraph 4.3 by TÜV ATEXtechnik GmbH (Notified Body Identification No.0035)
 Inspection Certificate EN10204-3.1B



Shanxi Taigang Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD
 NO.2 jianekoping, Taiyuan, Shanxi, P.R.China
 TEL: (0351)3013328 FAX: (0351)3017816
<http://www.tisco.com.cn>
 E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

MATERIAL	AISI304 No.2B Finish
SPECIFICATION	ASTM A240/A480 ASME SA240/SA480
L/C NO.	
CERTIFICATE NO.	20050636
DATE OF ISSUE	11

CUSTOMER
OLBERT

CONTRACT NO.
 1149

DATA OF
 2005/06/20

COIL	Product	Melting Furnace	Inspectors stamp	Mark of the Manufacturer	
				E-IVOD	Shanxi Taiyuan Stainless Steel Co.,ltd
NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
8	QBP1133	SA4-273-4ZB	1	20GA × 48 × C	8528
9	Y501898	SA4-419-4ZY	1	14GA × 48 × C	5396
10	4501977	SA4-348-12B	1	11GA × 48 × C	5182
11	4501969	SA4-416-4ZY	1	14GA × 48 × C	7709
12	4501968	SA4-415-4ZY	1	14GA × 48 × C	7495
13	4501965	SA4-367-12B	1	11GA × 48 × C	8127
14	4500491	SA5-1B-4ZJ	1	20GA × 48 × C	7668

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
QBP1133	0.049	0.470	1.090	0.023	0.003	18.340	8.050				0.039
Y501898	0.058	0.430	1.000	0.029	0.004	18.420	8.070				0.066
4501977	0.070	0.470	1.310	0.019	0.002	18.050	8.100				0.050
4501969	0.050	0.430	1.270	0.018	0.002	18.020	8.010				0.050
4501968	0.060	0.460	1.250	0.018	0.003	18.120	8.100				0.050
4501965	0.050	0.440	1.320	0.019	0.002	18.140	8.090				0.050
4500491	0.050	0.500	1.340	0.020	0.002	18.040	8.000				0.050

Mechanical Properties

Test No.	Tensile Rm N/mm ²	R _{0.2} Yield _{0.2%} N/mm ²	R _{0.5} Yield _{0.5%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
QBP1133-T	620	290		55				175
Y501898-T	665	289		60		83		
4501977-T	615	279		60		86		
4501969-T	655	298		61		84		
4501968-T	650	294		58		84		
4501965-T	690	283		60		85		
4500491-T	660	329		60				172

Surface and dimensions controlled: O.K.

Work Inspected: *✓* *✓* *✓* *✓*

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06-02-24

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